



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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647.7303

Job Sheet 201259



Part No: 647.7303

Job Qty: 1 pcs

Part Name: EC135 Cable Cutters (Removable Provisions Only)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV N/C IPP REV:A 12.10.05 NEW ISSUE DD VERF:JLM IPP REV:B 16.11.24 NEW ISSUE DD
VERF:JFS IPP REV:C 17.01.24 PER MPP-195 N/C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs ✓		10/21/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
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							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

Rosales, Oscar

OCT 21 2019



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Container No: S224869



Part: 647.7303

Job No: 201259

Serial No/Batch: S224869

Revision: n/c

Inspector:

Exp Date:

Instructions: FAA STC SR02307LA 16/11/2019 TC STC LoA RI

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				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
120 QC 4	1 pcs	10/21/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
130 Packaging 3-1 - Stock - B4B	1 pcs	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
135 DC - 1 - B4B	1 pcs	10/21/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
140 QC 21 - FG	1 pcs	10/21/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	
Part Op 110 - (Pick Kit) Descriptions: 120 - (QC4- 100% Inspect kits for completeness) 130 - Identify and pack for shipping as per PPP 647.7303					

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OCT 23 2019

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OCT 23 2019

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OCT 23 2019

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OCT 23 2019

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OCT 23 2019

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OCT 23 2019

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OCT 23 2019

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135 - (Document Control) Photocopy bluefile & type labels per PPP 647.7303

140 - (QC21- Final Inspection - Work Order Release)

(012516)

Job BOM				Job Allocation
Part / Item	Component Name	Quantity	Operation	Container
601.2045	RTV (LOCTITE 598) <i>Exp date 12/20 DAS</i>	1 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5164007 ✓
601.3011	P-Seal <i>17 1/4</i>	1.4000 ft (1.4 ea) ✓	110-Packaging 1 - Pick Kit	5006465 ✓
601.3119	Clevis Pin SEE P/N: AN665-34R	9-84 (4 ea) ✓	110-Packaging 1 - Pick Kit	5207590 ✓
647.0112	Strut Bracket	4 pcs (4 ea) ✓	110-Packaging 1 - Pick Kit	5220124 ✓
647.1701	Skid Deflector Assembly	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5222496 ✓
647.2511	Nut	4 pcs (4 ea) ✓	110-Packaging 1 - Pick Kit	5208448 ✓
647.7401	Upper Cutter Assembly	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5197952 ✓
647.7501	Lower Cutter Assembly	1 pcs (1 ea) ✓	110-Packaging 1 - Pick Kit	5185896 ✓
647.7701	Strut Assembly	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5178737 ✓
647.7702	Strut Assembly	2 pcs (2 ea) ✓	110-Packaging 1 - Pick Kit	5189768 ✓
AN3-11A	Bolt	4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5214962 ✓
AN316C4R	Nut, Jam	4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5208490 ✓
AN44-12A	Eyebolt	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5222628 ✓
AN44-5A	Eyebolt	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5156978 ✓
AN4C7A	Bolt	4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5142074 ✓
MS21042-08	Use MS21042L08	6 Ea (6 ea) ✓	110-Packaging 1 - Pick Kit	5205000 ✓
MS21042-3	Nut use MS21042L3 per QSI 017	4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5211533 ✓
MS21042L4	Nut	8 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
MS21266-2N	Grommet	1 Ea (1 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
MS27030-08-13	Screw	4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
MS27030-08-15	Screw Pan HD	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
NAS1140C0432R	Washer (AN960C416L)	8 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
NAS1149F0463P	Washer (AN960-416)	8 Ea (8 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
NAS1149F0532P	Washer (AN960-516L)	2 Ea (2 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
NAS1149F0832P	Washer (AN960-8)	12 Ea (12 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
NAS6603-12	Bolt	4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
NAS6603-16	Bolt	4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓
NAS6604-60	Bolt	4 Ea (4 ea) ✓	110-Packaging 1 - Pick Kit	5211567 ✓

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	601.2045	1	15	0
	601.3011	1	115	0
	601.3119	4	0	0
	647.0112	4	16	0
	647.1701	2	0	0
	647.2511	4	29	0
	647.7401	1	2	0
	647.7501	1	2	0
	647.7701	2	4	0
	647.7702	2	8	0
	AN3-11A	4	213	0
	AN316C4R	4	47	0
	AN44-12A	2	10	0
	AN44-5A	2	55	0
	AN4C7A	4	57	0
	MS21042-08	6	2	0
	MS21042-3	4	466	0
	MS21042L4	8	1,780	0
	MS21266-2N	1	14	0
	MS27039-08-13	4	319	0
	MS27039-08-16	2	59	0
	NAS1149C0432R	8	1,236	0
	NAS1149F0332P	12	3,173	0
	NAS1149F0463P	8	445	0
	NAS1149F0532P	2	1,442	0
	NAS1149FN832P	12	1,711	0
	NAS6603-12	4	23	0
	NAS6603-16	4	38	0
	NAS6604-66	4	6	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS									
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐						
Date: _____	Sequence #: _____	QTY Affected: _____				MRB (QS1042) _____					
Description Work Order Deviation		Disposition									
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Completed By _____		Lead hand / Supervisor _____				QC / QA Coordinator _____					



SUBJECT:
INSTALLATION INSTRUCTIONS
EC135 CCK

REPORT NO:
II135-21
Rev. F
11/01/16

Table 3: Parts List for Figure 3.5 and Figure 3.6

F/N	7301, 7321		7304, 7324		7307, 7327		PART NUMBER	DESCRIPTION
	7302, 7322	7303, 7323	7305, 7325	7306, 7326	7305, 7325	7308, 7328		
1		1					647.7401	UPPER CUTTER ASSY
11		2		2		2	647.7701	STRUT ASSY
14		2		2		2	647.0112	STRUT BRACKET
25	1		1		1		647.7820	CROSS BRACKET FWD
26	1		1		1		647.7818	MOUNTING CHANNEL
40		2		2		2	601.3119	CLEVIS (AN665-34R)
46		2		2		2	601.2826	BOLT (AN3-11A)
48		2		2		2	601.2669	BOLT (AN4C7A)
52		4		4		4	601.2973	LOCKNUT (MS21042-08)
53	15	2	15	2	15	2	601.2943	LOCKNUT (MS21042-3)
54		2		2		2	601.3209	LOCKNUT (MS21042L4)
55		2		2		2	601.3128	NUT (AN316C4R)
56	13		14		14		647.8510	INSERT
61		2		2		2	601.2988	SCREW (MS27039-0813)
62		2		2		2	601.3137	SCREW (MS27039-0816)
64	2		2		2		601.3069	SCREW (MS27039-1-09)
66	2		2		2		601.1953	SCREW (MS27039-1-12)
68	2		2		2		601.3012	SCREW (MS27039-1-15)
69	4		4		4		601.2637	SCREW (MS27039-1-16)
71	6		5		5		601.2829	SCREW (MS24694S54)
85		3		15		15	601.2764	WASHER (NAS1149FN832P)
86	23	4	17		17		601.1607	WASHER (NAS1149F0332P)
87		4	4		4		601.2638	WASHER (NAS1149F0432P)
95	1						647.7919	SHIM
96		REF		REF		REF	647.5701	GPS Mount Kit
97			1		1		647.7823	Cross Bracket Aft
98			1		1		647.2114	Upper U Channel
99				1			647.1404	Cutter Assy (Upper)
100				5		5	601.3962	Screw (MS27039-0827)
101				5		5	601.1541	Locknut (MS21042L08)
109			2		2		601.2910	Screw (MS27039-1-18)
111						1	647.1405	Cutter Assy (Upper)

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EC135 CCK

REPORT NO:
II135-21
Rev. F
11/01/16

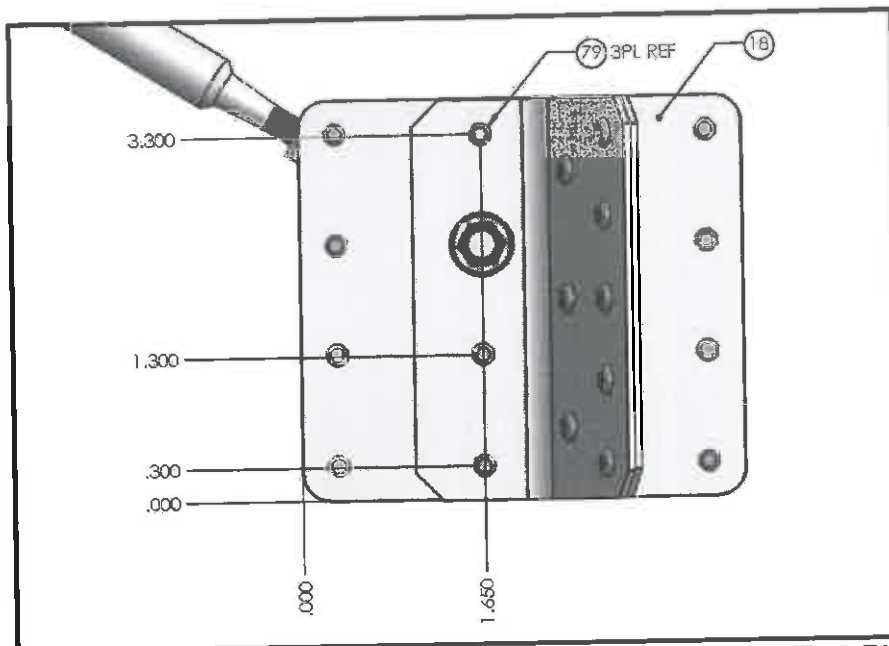


Figure 5.14: Lower Doubler Assy and Rivet Locations (TYP. 2 PL)

Table 16: Parts List for Figure 5.12 and Figure 5.12a

F/N	7301, 7331		7304, 7307, 7334		PART NUMBER	DESCRIPTION
	7302, 7332	7303, 7333	7305, 7332	7306, 7308, 7335		
2	0	1	0	1	647.7501	LOWER CUTTER ASSY
10	0	2	0	2	647.7702	STRUT ASSY
15	2	0	2	0	647.7910	ANGLE BRACKET
31	2	0	2	0	647.1811	SPACER
38	0	2	0	0	601.3131	Eye Bolt (AN44-5A)
40	0	2	0	2	601.3119	CLEVIS (AN665-34R)
48	0	2	0	2	601.2669	BOLT (AN4C7A)
49	0	4	0	0	601.1500	BOLT (NAS6603-12)
50	0	4	0	0	601.3130	BOLT (NAS6603-16)
52	0	2	0	2	601.2973	LOCKNUT (MS21042-08)
54	0	2	2	2	601.3209	LOCKNUT (MS21042L4)
55	0	2	0	2	601.3128	NUT (AN316C4R)
61	0	2	0	2	601.2988	SCREW (MS27039-0813)
76	16	0	16	0	601.0790	CHERRY RIVET (CR3213-4-3)
77	8	0	8	0	601.1915	CHERRY RIVET (CR3213-4-4)
79	6	0	6	0	601.2991	CHERRY RIVET (CR3213-4-6)
85	0	4	0	4	601.2764	WASHER (NAS1149FN832P)



SUBJECT:
INSTALLATION INSTRUCTIONS
EC135 CCK

REPORT NO:
II135-21
Rev. F
11/01/16

F/N	7301, 7331		7304, 7307, 7334		PART NUMBER	DESCRIPTION
	7302, 7332	7303, 7333	7305, 7332	7306, 7308, 7335		
86	0	4	0	4	601.1607	WASHER (NAS1149F0332P)
87	0	4	0	4	601.2638	WASHER (NAS1149F0432P)
108	0	0	0	4	601.3963	Bolt (93635A212)
110	0	0	0	2	601.3902	Eye Bolt

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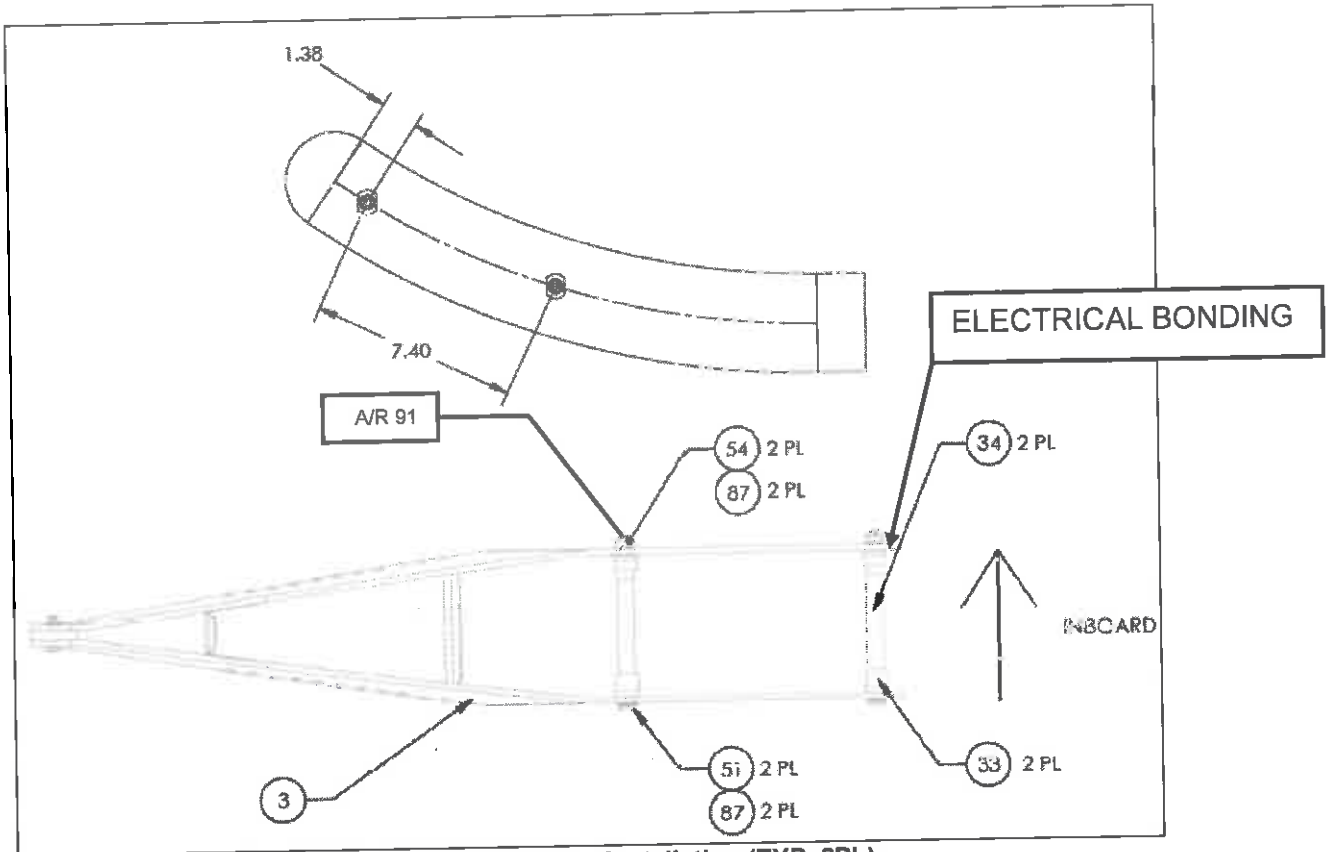


Figure 6.1: Skid Deflector Installation (TYP. 2PL)

Table 17: Parts List for Figure 6.1

F/N	7301, 7351		PART NUMBER	DESCRIPTION
	7302	7303		
3	0	1	647.1701	SKID DEFLECTOR ASSY
33	2	0	647.2510	SLEEVE
34	2	0	647.2511	NUT
51	0	2	601.3002	BOLT (NAS6604-66)
54	0	2	601.3209	NUT (MS21042L4)
87	0	2	601.2638	WASHER (NAS1149F0432P)